

Date: Friday, 5/25/2007 8:16:12 AM  
User: Kim Johnston

# Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE WELDMENT
Job Number	32573	Part Number	: D2530
Estimate Number	10333	Drawing Number	: D2530 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 5/25/2007 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 11 Type : SMALL /MED FAB	Due Date	: 6/15/2007
Previous Run	: 31787	Qty:	20 Um: Each:
Written By	:		
Checked & Approved By	: <u>07.05.28</u>		
Comment	: Est Rev:E Removed Purchasing 05-11-07 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 3.0602 f(s)/Unit Total : 61.2045 f(s)  
Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)  
Batch: M104627 FF 07-07-20 17

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536

2-Deburr

} FF 07-07-20 17

(PRO) →

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0 D2534 Lock Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

QTY Part # Description Batch  
2 D2534 Lock Plate 19X B31145

15X B32620

07/08/08 (17)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

2-Deburr

07/08/08 (17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2530 PAR #: N/A Fault Category: Prod - Sm Fab NCR: ☒ Yes No DQA: 1A Date: 07.08.13  
 QA: N/C Closed: 18 Date: 07.08.21

NCR: <u>32573</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/08/08</u>	<u>2.0</u>	<u>one part scan small Bress found in end of tube and having welded RC. Hammer error</u>	<u>[Signature]</u>	<u>scan and destroy and replace BN # <u>M103240</u></u>	<u>[Signature]</u> <u>07/08/08</u>	<u>En</u> <u>07/08/08</u>	<u>[Signature]</u>	<u>En</u> <u>07/08/07</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 32573

Part Number: D2530

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-08-08

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-08-08

8.0

POWDER COATING

POWDER COATING



M 102316



(17x)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-L 07/08/13

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SP 7/8/13 S

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

EP 07/08/13 (17)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-08-13

Job Completion



C 207/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

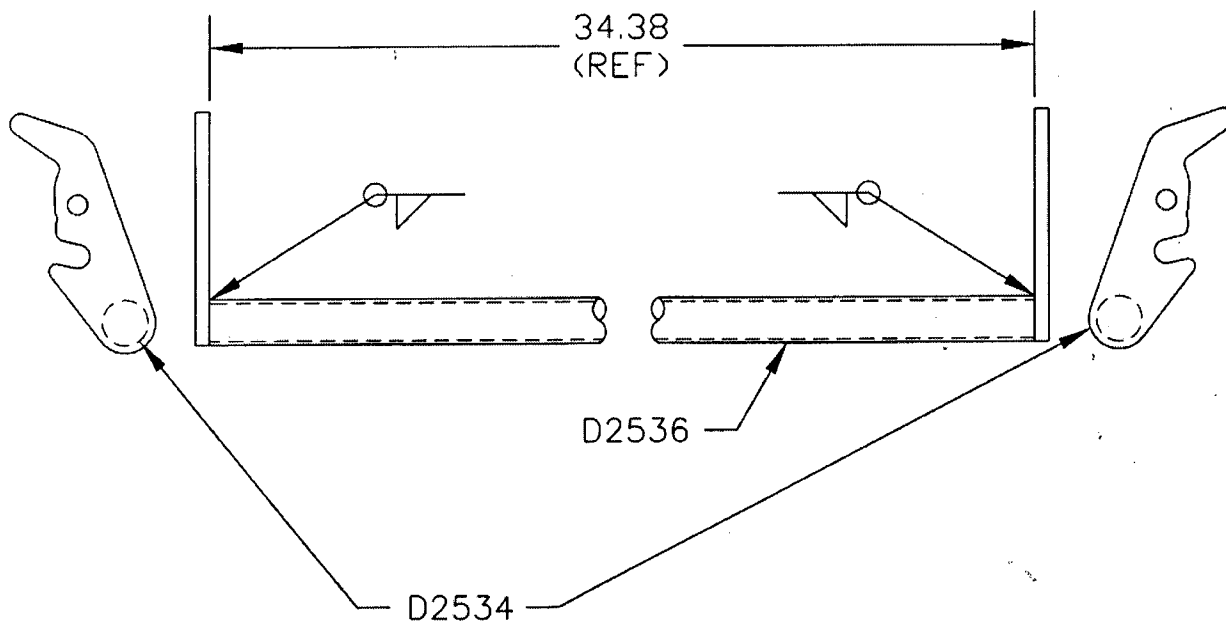
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>#</i>	APPROVED <i>#</i>	D2530	SHEET 1 OF 1
DATE		TITLE	
04.12.14		HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *#*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004 .
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **32573**

